

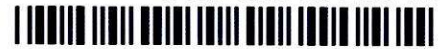


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2668-2

Job Sheet 208472



Part No: D2668-2

Job Qty: 6 pcs

Part Name: Saddle, RH, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/20

Job Tracking No:

Due Date: 4/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: D 02.03.15 Added DEO 9122 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	4/13/20		1.00	10.29	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 20/04/08
							HAAS - 4		
110	Conventional Mill - 1 - B4B	6 pcs	4/13/20		0.00	10.29	Conventional Mill - 1 - B4B		SBL 20/04/08
							Conventional Mill - 2 - B4B		
120	QC 2	6 pcs	4/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		WBS 20/4/18
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		



Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
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www.dartaerospace.com

Container No: S269394



Part: D2668-2

Job No: 208472

Serial No/Batch: S269394

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/08/20

						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
QC 8 - 3							
QC 8 - 32							
QC 8 - 33							
QC 8 - 35							
QC 8 - 39							
QC 8 - 4							
QC 8 - 44							
QC 8 - 45							
QC 8 - 49							
QC 8 - 58							
QC 8 - 8							
QC 8 - 9							
QC 8 - 68							
QC 8 - 67							
QC 8 - 1 (A)							
QC 8 - 47							
QC 8 - 40							
QC 8 - 52							
QC 8 - 23							
QC 8 - 57							
QC 8 - 76							
QC 8 - 61							
QC 8 - 66							
130	QC 8	6 pcs	4/13/20	0.00	0.00		
	Handfinish - 1-1 Chemical- B4B	6 pcs	4/13/20	0.00	0.48	Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 -	
						Plex 3/20/20 10:54 AM Dart.lajeunesse.marie	

WJ 10/4/19

DEB 20-04-21

				B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150	Powdercoat - 1 White GI(A)- B4B	6 pcs	4/13/20	0.00	0.46	Powdercoat - 1 - B4B
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
160	QC 3	6 pcs	4/13/20	0.00	0.00	QC 3 - 10
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
				QC 3 - 82		
170	Packaging 3-1 - Stock - B4B	6 pcs	4/13/20	0.00	0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	DAS
180 QC 21 - SA	6 pcs	4/13/20	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-90
				QC 21 - SA - 53	
					APR 21 2020
Part Op 100 - (HAAS CNC Vertical Machine) Descriptions: 110 - (Manufacture as per dwg) 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-001	Saddle Billet	6 pcs (1 ea)	100-HAAS 4 Axis	S235 965	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-001	6	32	0	
Part Specifications					
Specifications could not be found.					

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208472

DART AEROSPACE LTD	Work Order:	208409
Description: 206 Saddle, Inboard, Right side	Part Number:	D2668-2
Inspection Dwg: D2668 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.119	.119	.120	.120	.120
B	0.100	0.140		.130	.130	.130	.130	.130
C	1.125	1.145		1.135	1.135	1.135	1.135	1.135
D	0.615	0.685		.660	.660	.660	.655	.655
E	0.240	0.260		.252	.252	.250	.251	.251
F	1.313	1.343		1.322	1.320	1.320	1.321	1.320
G	0.210	0.220		.220	.221	.221	.220	.220
H	0.100	0.180		.133	.133	.133	.130	.133
I	2.470	2.510		2.490	2.490	2.490	2.492	2.494
J	1.565	1.585		1.575	1.575	1.575	1.575	1.575
K	0.235	0.240		.237	.237	.237	.237	.237
L	0.100	0.120		.115	.113	.113	.113	.113
M	0.990	1.010		1.000	1.000	1.001	1.001	1.001
N	0.510	0.515		.512	.512	.512	.512	.512
O	5.990	6.010		6.002	6.000	6.002	6.001	6.001
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		.312	.312	.312	.312	.312
S	0.315	0.322		.316	.316	.316	.316	.316
T	1.995	2.005		2.000	2.000	2.000	2.000	2.000
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.796	.796	.797	.796	.796
W	1.040	1.060		1.048	1.049	1.049	1.048	1.048
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		.258	.258	.258	.258	.258
Z	0.912	0.932		.920	.920	.919	.921	.920
AA	0.490	0.510		.497	.498	.497	.499	.497
AB	0.178	0.198		.188	.188	.188	.188	.188
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL	Date: 20/04/08
Audited by: [Signature]	Date: 20/4/18
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	[Signature]

208472
208469

DART AEROSPACE LTD				Work Order:	
Description: 206 Saddle, Inboard, Right side				Part Number: D2668-2	
Inspection Dwg: D2668 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	2	3	4	5
A	0.100	0.140		.119				
B	0.100	0.140		.130				
C	1.125	1.145		1.133				
D	0.615	0.685		.655				
E	0.240	0.260		.252				
F	1.313	1.343		1.320				
G	0.210	0.220		.220				
H	0.100	0.180		.130				
I	2.470	2.510		2.492				
J	1.565	1.585		1.575				
K	0.235	0.240		.237				
L	0.100	0.120		.113				
M	0.990	1.010		1.000				
N	0.510	0.515		.512				
O	5.990	6.010		6.000				
P	1.245	1.255		1.250				
Q	2.495	2.505		2.500				
R	0.312	0.318		.312				
S	0.315	0.322		.316				
T	1.995	2.005		2.000				
U	1.357	1.367		1.362				
V	0.787	0.807		.796				
W	1.040	1.060		1.049				
X	1.674	1.684		1.679				
Y	0.256	0.262		.258				
Z	0.912	0.932		.922				
AA	0.490	0.510		.497				
AB	0.178	0.198		.188				
AC								
AD								
AE								
Accept/Reject								

Measured by: SBC	Date: 20/04/08
Audited by: VHS	Date: 20/4/18
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					